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URGENT

RBW6521A00138-W142AH-

002-3T-3

Job Sheet 191308



Part No: RBW6521A00138-W142AH-002-3T-3 **Job Qty:** 4 pcs

Part Name: LH Side Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/26/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 3/20/19

Type: SOLD

Note: DWG RBW6521A

Ship Via:

DP Verify DD

Op No	Operation
100	Waterjet - Omax - 1
110	QC 2

→ Need to (drill) tap deeper

→ Drawing calls for .6

→ Parts are .418" deep

All parts

→ 3 parts)
3 hole pattern
off centerline
by .008 to .0085

* bolts K-32 are .188"
- clearance holes are .201
so it only allows .0065
off center on one side

Supplier	Lead Time	Sign-off
Omax		
1		
2		
4		
7		
9		
2		
QC 2 - 20		
- 22		
- 23		
- 25		
- 32		
- 33		
- 35		
- 39		
- 4		
- 40		
- 44		
- 45		
- 48		
- 49		
- 50		
- 51		
- 52		
- 54		
- 56		
- 57		
QC 2 - 62		
QC 2 - 63		
QC 2 - 8		
NV5000 - 1 - B4B		
NV5000 - 2 - B4B		
QC 2 - 1		

CRAP

2/19/2019

4 pcs	3/20/19	0.00 4.00	NV5000 - 1 - B4B	PJ 19-03-06
4 pcs	3/20/19	0.00 0.00	NV5000 - 2 - B4B	PJ 19-03-06
			QC 2 - 1	

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				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
140	QC 8	4 pcs	3/20/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
150	Outsource - 12 - Black Oxide	4 pcs	3/20/19		GRO002-VC
160	Packaging 2-1 - Receive - B4B	4 pcs	3/20/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B

				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
170	QC 6	4 pcs	3/20/19	0.00 0.00	QC 6 - 42
					QC 6 - 9
					QC 6 - 68
					QC 6 - 61
180	Packaging 3-1 - Stock - B4B	4 pcs	3/20/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
190	QC 21 - SA	4 pcs	3/20/19	0.00 0.00	QC 21 - SA - 21

2/26/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

QC 21 - SA - 70

Part Op 100 - 1-Cut as per DWG. DWG. Rev: A PROG. Rev: A 2-Deburr if necessary
Descriptions: 120 - 1-Machine as per folio FC FOLIO REV: DWG REV: 2-Deburr
150 - -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class
1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is
required
160 - -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-S-0.500	AISI 4140 Steel Sheet	.1960 sf (.049 ea)	100-Waterjet - Omax - 1	

Job Allocations

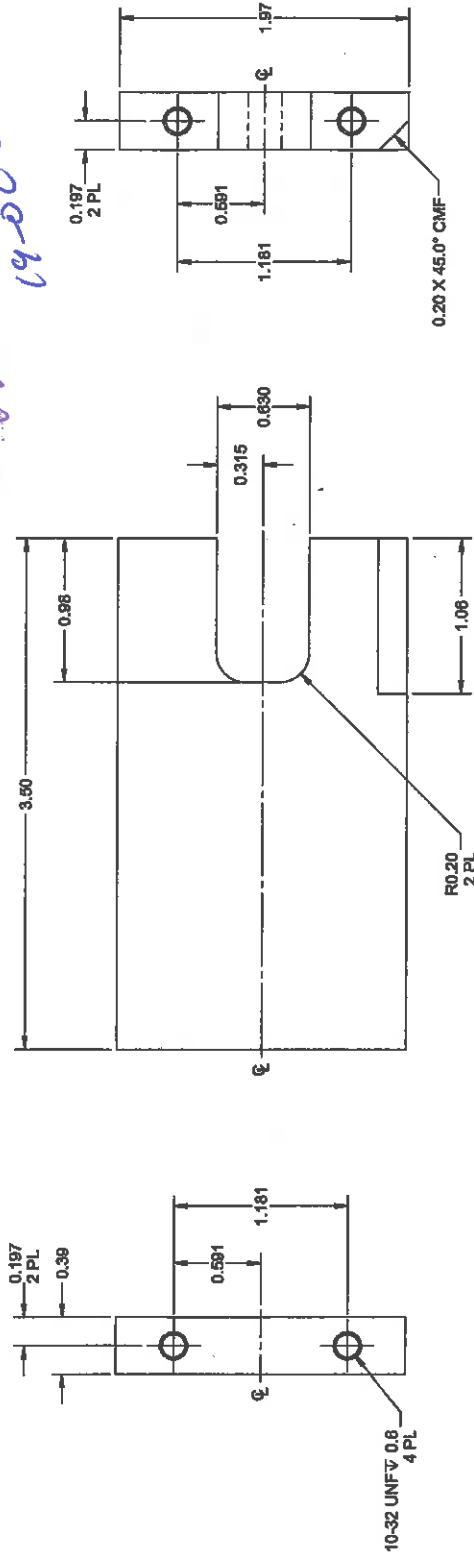
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	MT-4140-S-0.500	0	0	0

Part Specifications

Specifications could not be found.

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
191308 MJS
19-02-22



RBW6521A00138-W142AH-002-3T-3 LH SIDE BRACKET

- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-6173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81308 AND WIPE OFF EXCESS
 - 4) TOLERANCES:
XXX = $\pm 0.005"$ $\pm 0.1"$
XXXX = $\pm 0.008"$ $\pm 0.1"$
XXXXX = $\pm 0.005"$ $\pm 0.1"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	DP	RBW6521A00138-W142AH-002-3T
APPROVED	19/02/22	TITLE
DATE	12/24/2018	SCALE
		NTS
		SHEET 4 OF 5



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS			
		Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)				
Description Work Order Deviation		Disposition						
Completed By		Lead hand / Supervisor						
QC / QA Coordinator								
Root Cause		FAULT CATEGORY						
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐				
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐				
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐				
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐				
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐					
Human Factors ☐	Other/Details: _____							